



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A95-0505-00
Job Sheet R191280



Part No: RBE703A95-0505-00

Job Qty: 7 pcs

Part Name: Hose, Main Gear Box Tail Gear Box Draining



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No: ECN19-563

Due Date: 3/5/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBE703A95-0505-00 Rev 9 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	7 pcs	3/5/19	3/5/19	0.00	7.00	Small Fab - 1		nlc
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	7 pcs	3/5/19	3/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	7 pcs	3/5/19	3/5/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S157887



Part: RBE703A95 - 0505 - 00

Job No: R191280

Serial No/Batch: S157887

Revision: L

Inspector:

Exp Date:

Instructions:

Date: 03/01/19

DAS
40
9-89
DAS
9
9-89

MAR 06 2019

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	RLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	7 pcs	3/5/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **110** - -Assemble and package as per DWG. Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of
 Descriptions: the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into
 packaging (if applicable).
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304TR0.375W.065	304 Round Tube .375 X .065W	.5810 ft (.083 ea)	110-Small Fab - 1	5145223
RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	7 pcs (1 ea)	110-Small Fab - 1	5116692

BFTN

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	M304TR0.375W.065	1	57	0
	RBE703A95-0505-00	7	0	0

Part Specifications	
Specifications could not be found.	

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date:	19.02.26	Job No.:	RB18-EUROCOPTER	ADR Yes/No:	N	ADR Date:		ECN #:	19- 563
Product No.:	DART TOOLING EUROCOPTER			Created By:	VM	Approved By:	WSP		
Product Name:	TGB DRAIN TUBE			Checked By:	Emt				

Reason for Change:
ASSEMBLY ISSUE

Documents Released:

RBE703A95-0505-00 REV L

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 19-563

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		19.02.26
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		19.02.26
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MD		19.02.26
17	Update / Verify Authorized Release Certificate Database	Y	N	MD	19.02.26
18	Create / Update Change Record Form / Item Card Database	N	Y	MD	
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

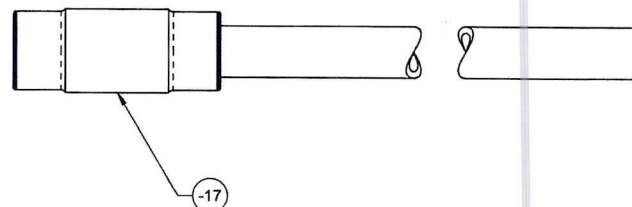
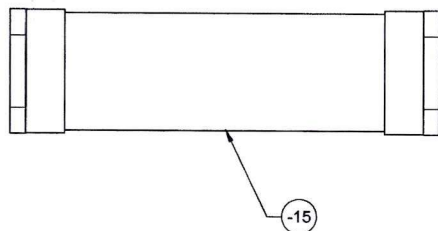
Description / Action:

STOCK CAN BE REWORK , SEE RBE703A95-0505-00 REV L DRAWING FOR MORE INFO
RELEASE RBE703A95-0505-00 REV L DRAWING
PLACE DRAWING RBE703A95-0505-00 REV 9 IN SUPERCEED FOLDER
CLOSE URF19-563

ECN Verified & Complete: _____

Date: _____

ITEM #	QTY	PART #	PART TITLE
-15	1	RBE703A95-0505-00-15	TGB DRAIN TUBE QUILL ASSEMBLY
-17	1	RBE703A95-0505-00-17	TGB DRAIN TUBE HOSE ASSEMBLY



RBE703A95-0505-00 TGB DRAIN TUBE

8

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

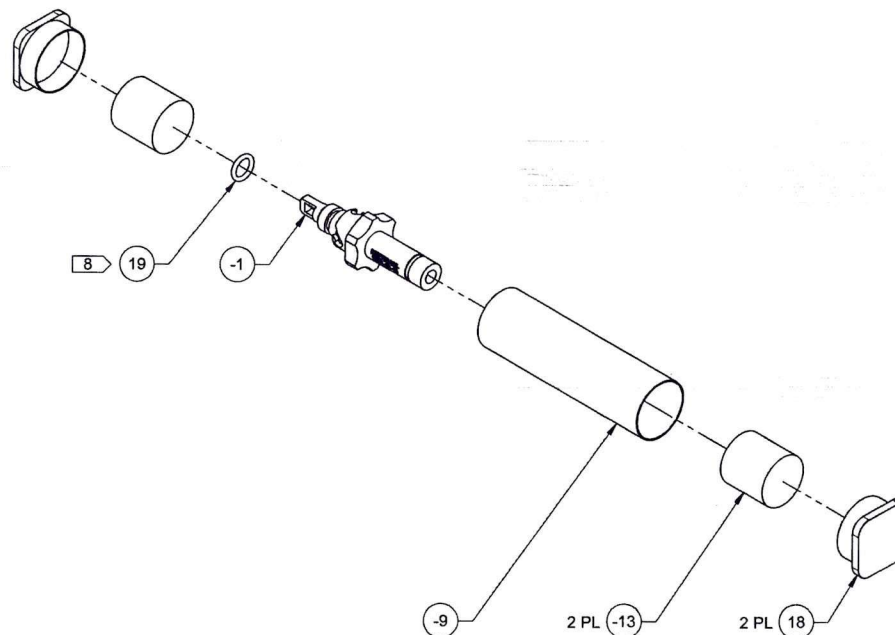
- 6) IDENTIFICATION: N/A

- 7) ASSEMBLE AS SHOWN

- 8) PLACE ITEM -17 COILED INTO A TIGHT FITTING SEALED PLASTIC BAG WITH ITEM -15

SEE PREVIOUS REVISION FOR MORE INFORMATION		19-563	KPT
UPDATED DRAWING TEMPLATE			
ADDED ITEMS -15 AND -17			
-1 REMOVED .02 X 30° CHAMFER. REMOVED 0.108 DIM. DIM WAS 2.97 MAX IS 2.970/2.965			
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KPT		
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	W		
DATE 2/26/2019		REV. L	SHEET 1 OF 6
		SCALE	NTS

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0505-00-1	QUILL
-9	1	RBE703A95-0505-00-9	TUBE
-13	2	RBE703A95-0505-00-13	FOAM
18	2	McMaster#2044T67 OR EQUIV.	VINYL END CAP FOR 1.09" ID. SHIPPING TUBE
19	1	McMaster#9263K173 OR EQUIV.	VITON O-RING 9 mm ID. X 13 mm OD. X 2 mm WD.



RBE703A95-0505-00-15 TGB DRAIN TUBE QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

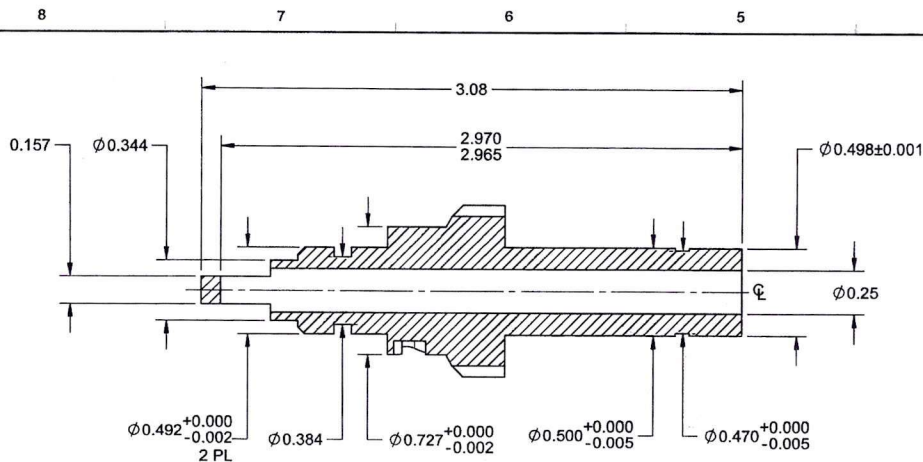
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

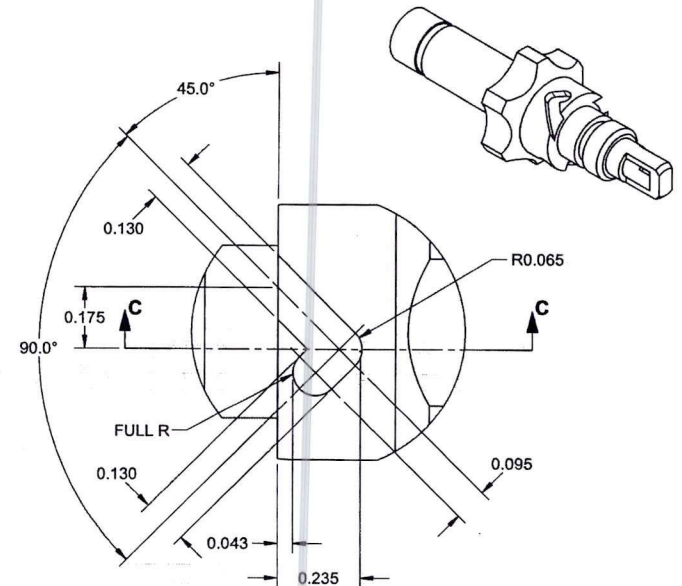
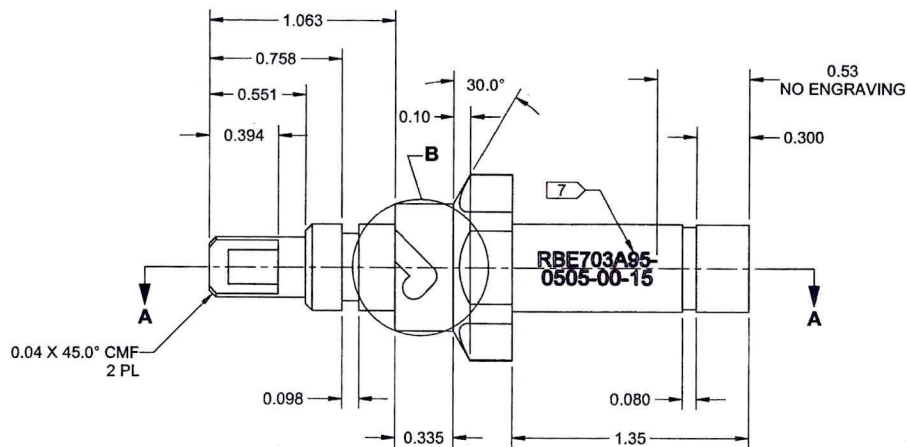
7) ASSEMBLE AS SHOWN

8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

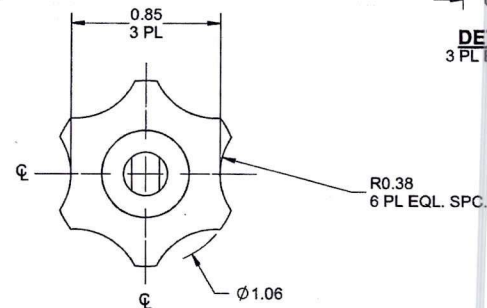
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE SCALE NTS	REV. L
DRAWN	KPT		SHEET 2 OF 6
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	<i>[Signature]</i>		
DATE 2/26/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



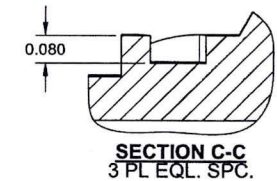
SECTION A-A



DETAIL B
3 PL EQL. SPC.



RBE703A95-0505-00-1 QUILL



SECTION C-C
3 PL EQL. SPC.

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. L
MFG. APPR.	DP	RBE703A95-0505-00	SHEET 3 OF 6
APPROVED	<i>VP</i>	TITLE	SCALE
DATE	2/26/2019	TGB DRAIN TUBE	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D

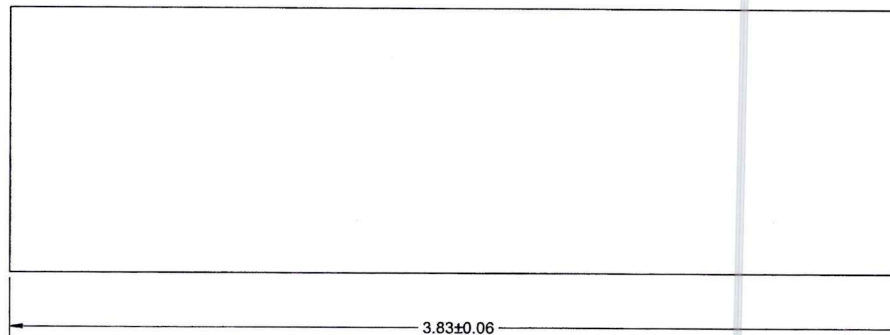
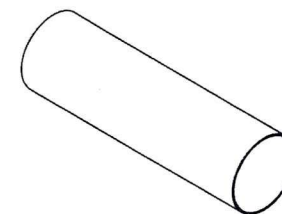
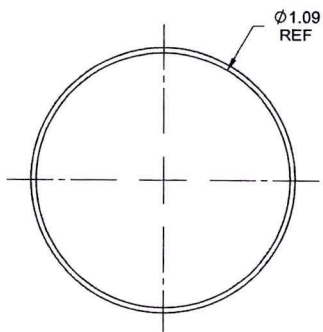
D

C

C

B

B



RBE703A95-0505-00-9 TUBE

NOTES:

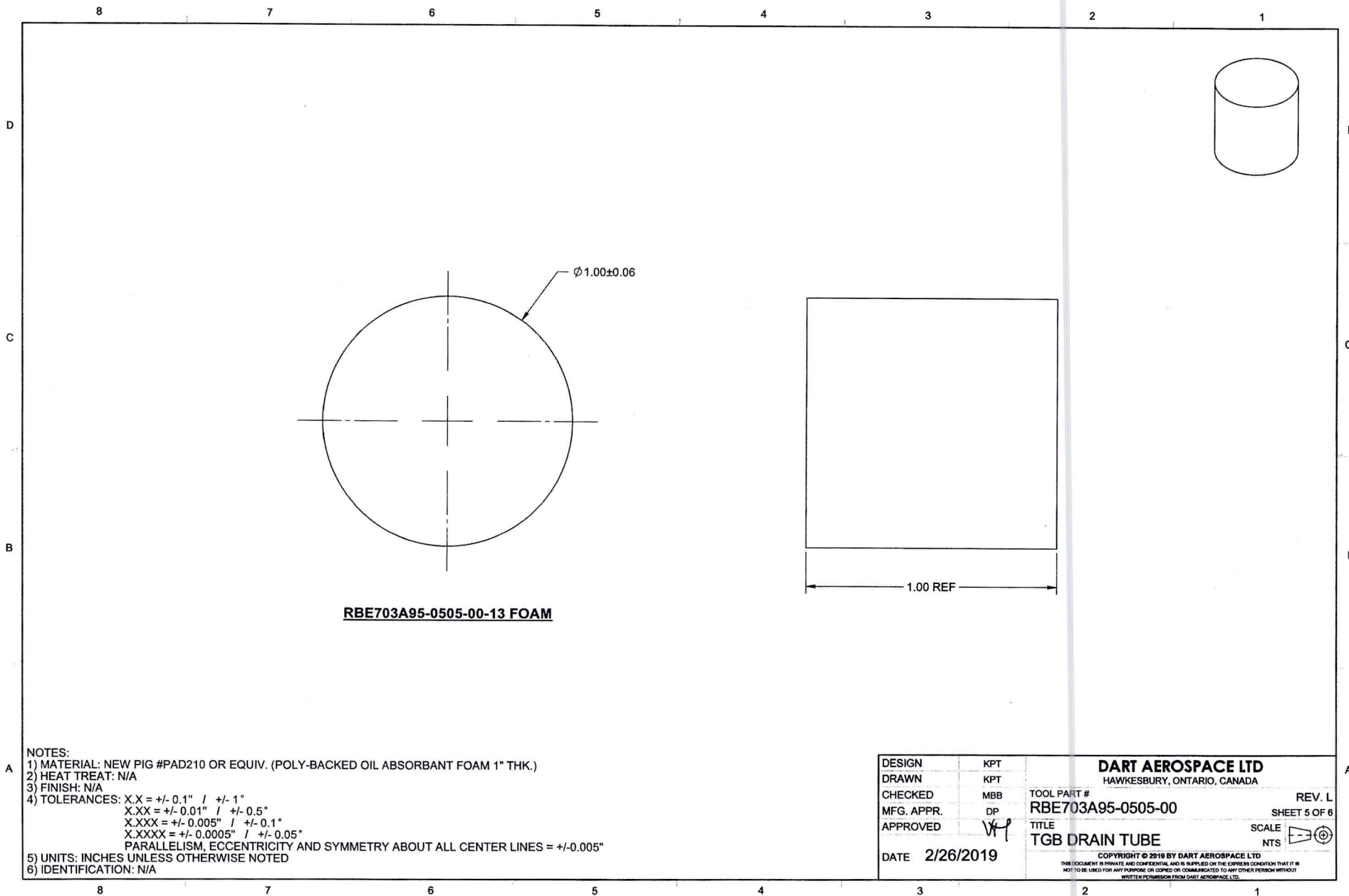
- 1) MATERIAL: McMaster#2044T47 OR EQUIV. (POLYETHYLENE PLASTIC SHIPPING TUBE 1.09" ID.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. L
MFG. APPR.	DP	RBE703A95-0505-00	SHEET 4 OF 6
APPROVED	VP	TITLE	SCALE
		TGB DRAIN TUBE	NTS
DATE	2/26/2019	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

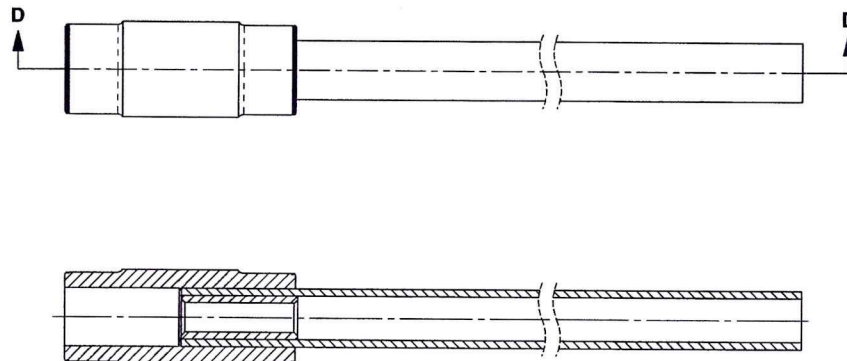
8 7 6 5 4 3 2 1

A

A



ITEM #	QTY	PART #	PART TITLE
20	1	DTSP10001	SLEEVE
21	1	Kuri-Tec#K010-0608 OR EQUIV.	CLEAR PVC TUBING 1/2" OD. X 3/8" ID. X 84" LG.
22	1	McMaster#51495K116 OR EQUIV.	NICKEL-PLATED BRASS PUSH-TO-CONNECT 1/2" OD. TUBE FITTING

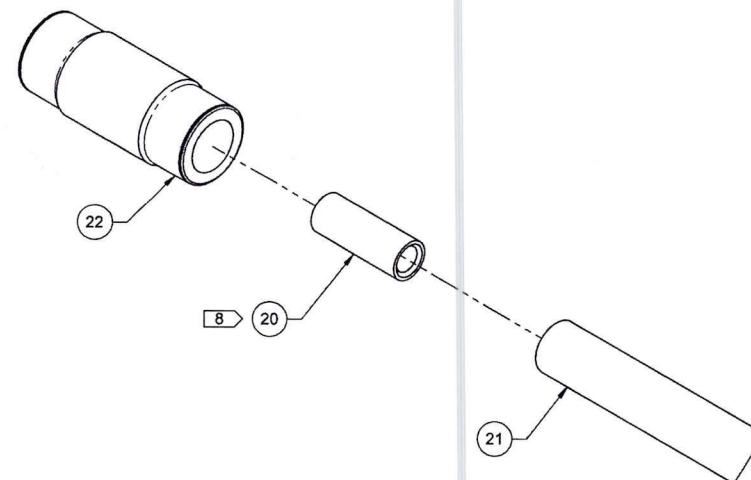


SECTION D-D

RBE703A95-0505-00-17 TGB DRAIN TUBE HOSE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 20 INTO ONE END OF ITEM 21 UNTIL FLUSH



DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. L
DRAWN	KPT		SHEET 6 OF 6
CHECKED	MBB		SCALE
MFG. APPR.	DP		NTS
APPROVED	<i>[Signature]</i>		
DATE 2/26/2019			